

Work Order ID 112495

112495

Page 1

January-30-14 11:45:49 AM

Item ID: D3259-042 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Access Panel Assy RH
 Start Date: 1/30/14 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 1/30/14 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: MLS Date: 14-01-31 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|-----------------------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D3259 | Rev B | | | | | | | | |
| 100 | Pick Kit | 0.00 | | | | | | | |
| *100* | | | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | <u>4</u> <u>FF 14-09-10</u> |
| Packaging | | | | | | | | | |
| 110 | Small Fab | 0.00 | | | | | | | |
| *110* | | | | | | | | | |
| Small Fab | Memo | 0.00 | | | | | | | <u>4</u> <u>FF 14-09-10</u> |
| Small Fab | Assemble D3259-041 as per Dwg D3259 .Note:Keep .040" Gap all around door. | | | | | | | | |
| 120 | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| *120* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | <u>4</u> <u>FF 14-9-11</u> |
| Quality Control | | | | | | | | | |

DAE
38
9-86 14-9-11

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

| | | | | | | | | | | | |
|--|------|------|-----|--|-------------------|---|-------------|--------------|--------------|--|--|
| Work Order: _____ Part No. _____ NCR No. _____ | | | | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/> | | AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div> | | | | | |
| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector | | |
| Design | | | | | | | | | | | |
| Doc/Data | | | | | | | | | | | |
| Equip/Tooling | | | | | | | | | | | |
| Handling/Pre | | | | | | | | | | | |
| Material | | | | | | | | | | | |
| Operator | | | | | | | | | | | |
| Offset/Setup | | | | | | | | | | | |
| Process | | | | | | | | | | | |
| Supplier | | | | | | | | | | | |
| Training | | | | | | | | | | | |
| Transport | | | | | | | | | | | |
| Unapproved | | | | | | | | | | | |

| FAULT CATEGORY | | | |
|--|--|---|--|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function | <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence | <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other |

January-30-14 11:45:49 AM

1 12495

Page 2

Accept

N900040100

```

Setup  Start  *NS1*
      Stop   *NS2*

```

| | | |
|-------------------------------|------------------------|------------|
| Start Date: 1/30/14 | Start Qty: 4.00 | *4* |
| Required Date: 1/30/14 | Req'd Qty: 4.00 | *4* |

Cust Item ID:
Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

| | | |
|-----|-------|-------|
| Run | Start | *NR1* |
| | Stop | *NR2* |

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

| Tool ID | Tool # | Plan Code |
|---------|--------|-----------|
|---------|--------|-----------|

| Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---------------|---------------|------------------|----------------|
|---------------|---------------|------------------|----------------|

130

Identify as per dwg & Stock Location: ST453 0.00

0.00

130

Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00


140

QC

Memo

0.00

Quality Control

14/9/12 
mf
14-9-11

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

| | | | | | | | | | | | | | | | | | | |
|--|--|--|--------------------------------------|------------------------------------|------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--|----------------------------------|--|------------------------------------|--|--------------------------------|------------------------------------|------------------------------------|-----------------------------------|--|
| Work Order: _____ Part No. _____ NCR No. _____ | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/> | AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table> | Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | |
| Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | | | | | | | | | | | | | | | | |

| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Design | | | | | | | | | |
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

| | | |
|--|--|---|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function | <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence |
| | | <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge |
| | | <input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other |

Picklist Print

January-30-14 2:52:23 PM

Page 1

Work Order ID: 112495

112495

Parent Item: D3259-042

D3259-042

Parent Item Name: Access Panel Assy RH

Start Date: 1/30/14

Required Date: 1/30/14

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 07-07-19 JLM Verified By:EC IPP REV
B:AS PER REV B 10-05-19 JLM VERIFIED BY:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

| | | | | | | | | | | | | | |
|-----------------------|--|-----------|----|--|--|-----|------|-----------|----|-----------|--------------------|--|--|
| MS20470AD3-5 RIVET | | Purchased | No | | | 100 | Each | 3,303.000 | 10 | 40 | | | |
| | | | | | | | | | | ** | <u>FF 14-09-10</u> | | |

| | | | | <u>Location</u> | | | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | |
|-----------------------|--|--------------|----|-----------------|--|-----|------|----------------|---|-----------------|--------------------|-----------|--|
| | | | | GA | | | | 3303 | | | | | |
| | | | | 9682 | | | | 3303 | | | | <u>40</u> | |
| D3161-5 Hinge 9.9" | | Manufactured | No | | | 110 | Each | 8.0000 | 1 | 4 | | | |
| | | | | | | | | | | ** | <u>FF 14-09-10</u> | | |

| | | | | <u>Location</u> | | | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | |
|------------------|--|--------------|----|-----------------|--|-----|------|----------------|---|-----------------|--|----------|--|
| | | | | ST031 | | | | 8 | | | | | |
| | | | | 107989 | | | | 2 | | | | <u>2</u> | |
| | | | | 89168 | | | | 6 | | | | <u>2</u> | |
| D3259-1 Panel | | Manufactured | No | | | 110 | Each | 5.0000 | 1 | 4 | | | |

| | | | | | | | | | | | | | |
|--|--|--|--|-----------------|--|--|--|----------------|--|-----------------|--------------------|----------|--|
| | | | | | | | | | | ** | <u>FF 14-09-10</u> | | |
| | | | | <u>Location</u> | | | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | |
| | | | | ST180a | | | | 5 | | | | <u>3</u> | |
| | | | | 105368 | | | | 4 | | | | <u>1</u> | |
| | | | | 90120 | | | | 1 | | | | | |

| | | | | | | | | | | | | | |
|--------------------|--|--------------|----|--|--|-----|------|--------|---|-----------|--------------------|--|--|
| D3259-4 Doubler | | Manufactured | No | | | 110 | Each | 4.0000 | 1 | 4 | | | |
| | | | | | | | | | | ** | <u>FF 14-09-10</u> | | |

| | | | | <u>Location</u> | | | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | |
|--|--|--|--|-----------------|--|--|--|----------------|--|-----------------|--|----------|--|
| | | | | ST181 | | | | 4 | | | | <u>4</u> | |
| | | | | 91961 | | | | 4 | | | | | |

Picklist Print

January-30-14 2:52:23 PM

Page 2

Work Order ID: 112495

112495

Parent Item: D3259-042

D3259-042

Parent Item Name: Access Panel Assy RH

Start Date: 1/30/14

Required Date: 1/30/14

Start Qty: 4.00

Required Qty: 4.00

D3259-5 Manufactured No 110 Each 9.0000 1 4

D3259-5

Spacer

FF 14-09-10

Location

Loc Qty

Loc Code

ST181

9

107929

8

71682

1

4

D3259-7 Manufactured No 110 Each 12.0000 1 4

D3259-7

Door

FF 14-09-10

Location

Loc Qty

Loc Code

ST181

12

108582

10

90847

2

4

D3260-1 Manufactured No 110 Each 13.0000 2 8

D3260-1

Spring

FF 14-09-10

Location

Loc Qty

Loc Code

ST035

13

72234

13

3
5

D3972-5 Manufactured No 110 Each 163.0000 2 8

D3972-5

Grommet, Half, Dzus

FF 14-09-10

Location

Loc Qty

Loc Code

ST079

163

98113

163

0

Picklist Print

January-30-14 2:52:24 PM

Work Order ID: 112495

112495

Parent Item: D3259-042

D3259-042

Parent Item Name: Access Panel Assy RH

Start Date: 1/30/14

Required Date: 1/30/14

Start Qty: 4.00

Required Qty: 4.00

D3973-5 Manufactured No

110 Each 24.0000 2 8

D3973-5

**

Receptable, Rigid, Dzus

FF 14-09-10

Location

Loc Qty

Loc Code

ST079 112405
108031
58759

24
20
4

8

D3974-20 Manufactured No

110 Each 22.0000 2 8

D3974-20

**

Stud, Wing Head, 5/16 Dzus

FF 14-09-10

Location

Loc Qty

Loc Code

ST079
58761

22
22

8

MS20426AD4-4 Purchased No

110 Each 3,436.000 4 16

MS20426AD4-4

**

Rivet

FF 14-04-01

Location

Loc Qty

Loc Code

GA
129090
ST334
125445

339
339
3097
3097

8

MS20470AD3-4 Purchased No

110 Each 7,784.000 36 144

MS20470AD3-4

**

Rivet, Universal Head

FF 14-09-10

Location

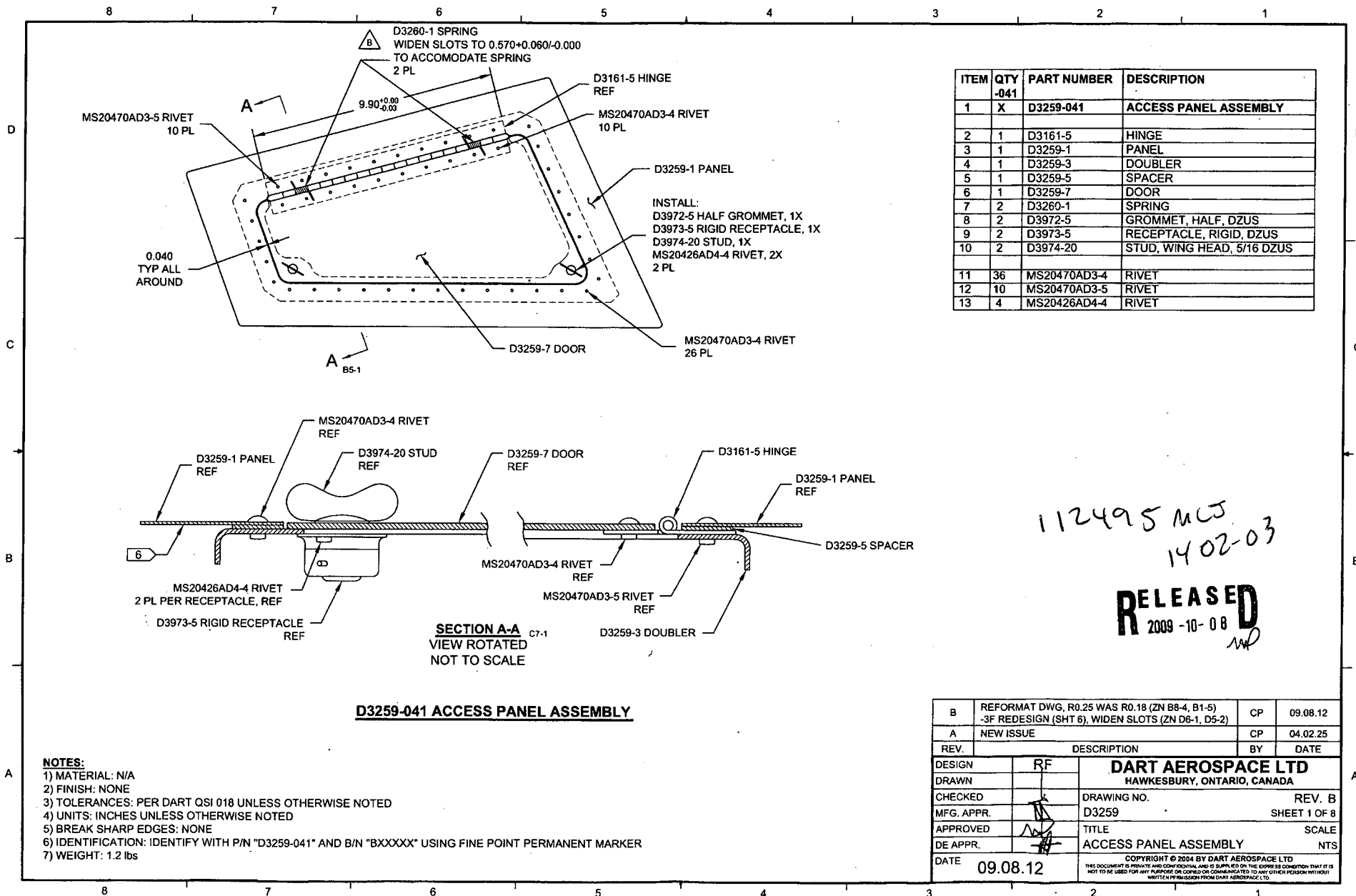
Loc Qty

Loc Code

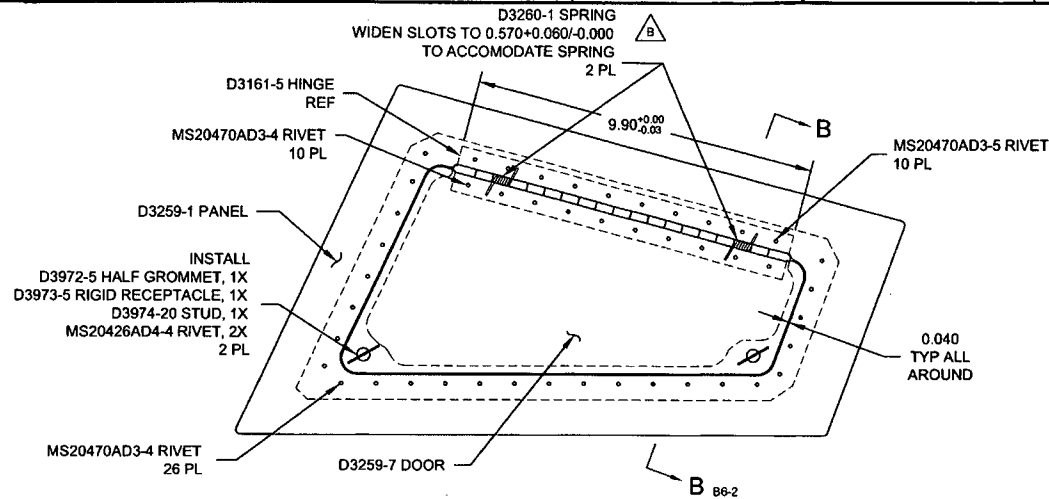
ST
111477
ST319
111477

56
56
7728
7728

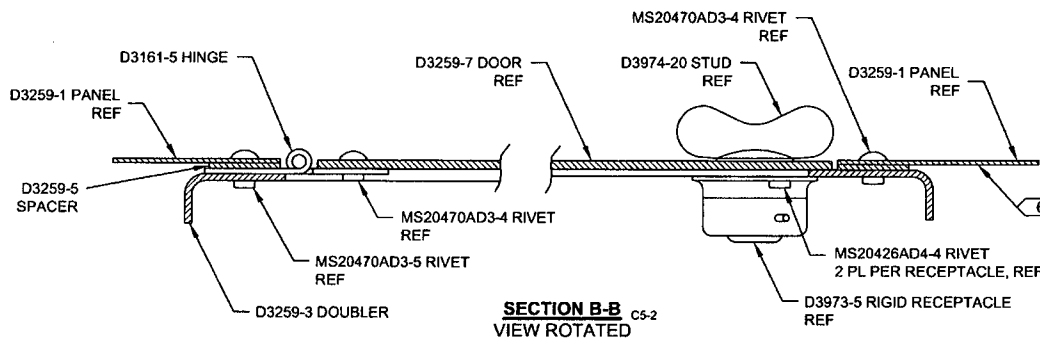
40



8 7 6 5 4 3 2 1



| ITEM | QTY | PART NUMBER | DESCRIPTION |
|------|-----|--------------|----------------------------|
| 1 | X | D3259-042 | ACCESS PANEL ASSEMBLY |
| 2 | 1 | D3161-5 | HINGE |
| 3 | 1 | D3259-1 | PANEL |
| 4 | 1 | D3259-4 | DOUBLER |
| 5 | 1 | D3259-5 | SPACER |
| 6 | 1 | D3259-7 | DOOR |
| 7 | 2 | D3260-1 | SPRING |
| 8 | 2 | D3972-5 | GROMMET, HALF |
| 9 | 2 | D3973-5 | RECEPTACLE, RIGID, DZUS |
| 10 | 2 | D3974-20 | STUD, WING HEAD, 5/16 DZUS |
| 11 | 36 | MS20470AD3-4 | RIVET |
| 12 | 10 | MS20470AD3-5 | RIVET |
| 13 | 4 | MS20426AD4-4 | RIVET |



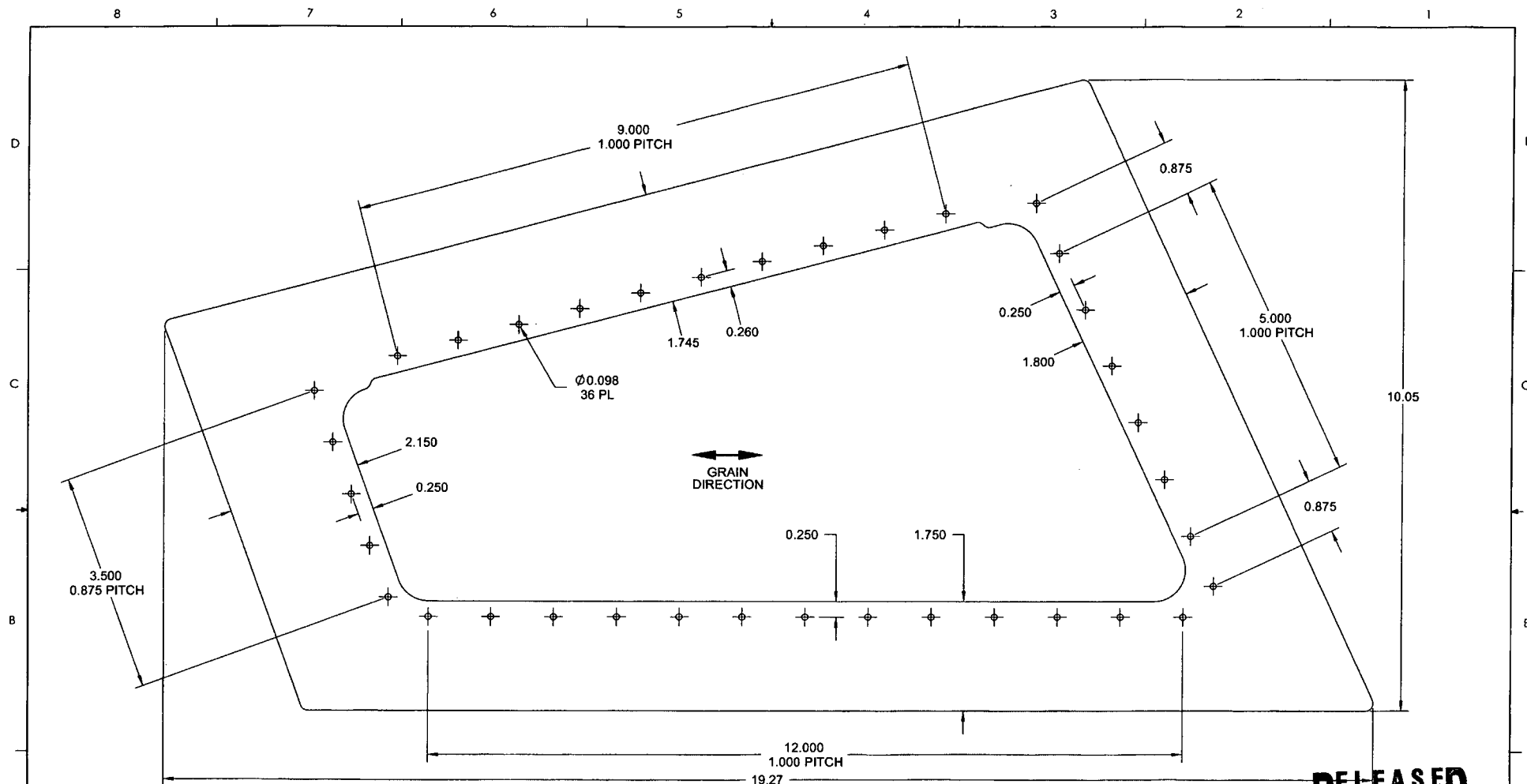
D3259-042 ACCESS PANEL ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH P/N "D3259-042" AND B/N "BXXXXX" USING FINE POINT PERMANENT MARKER
- 7) WEIGHT: 1.2 lbs

RELEASED
2009-10-08

| | | |
|------------|----------|---|
| DESIGN | RF | DART AEROSPACE LTD |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA |
| CHECKED | | DRAWING NO. REV. B |
| MFG. APPR. | | D3259 SHEET 2 OF 8 |
| APPROVED | | TITLE SCALE |
| DE APPR. | | ACCESS PANEL ASSEMBLY NTS |
| DATE | 09.08.12 | COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR CONVEYED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD |



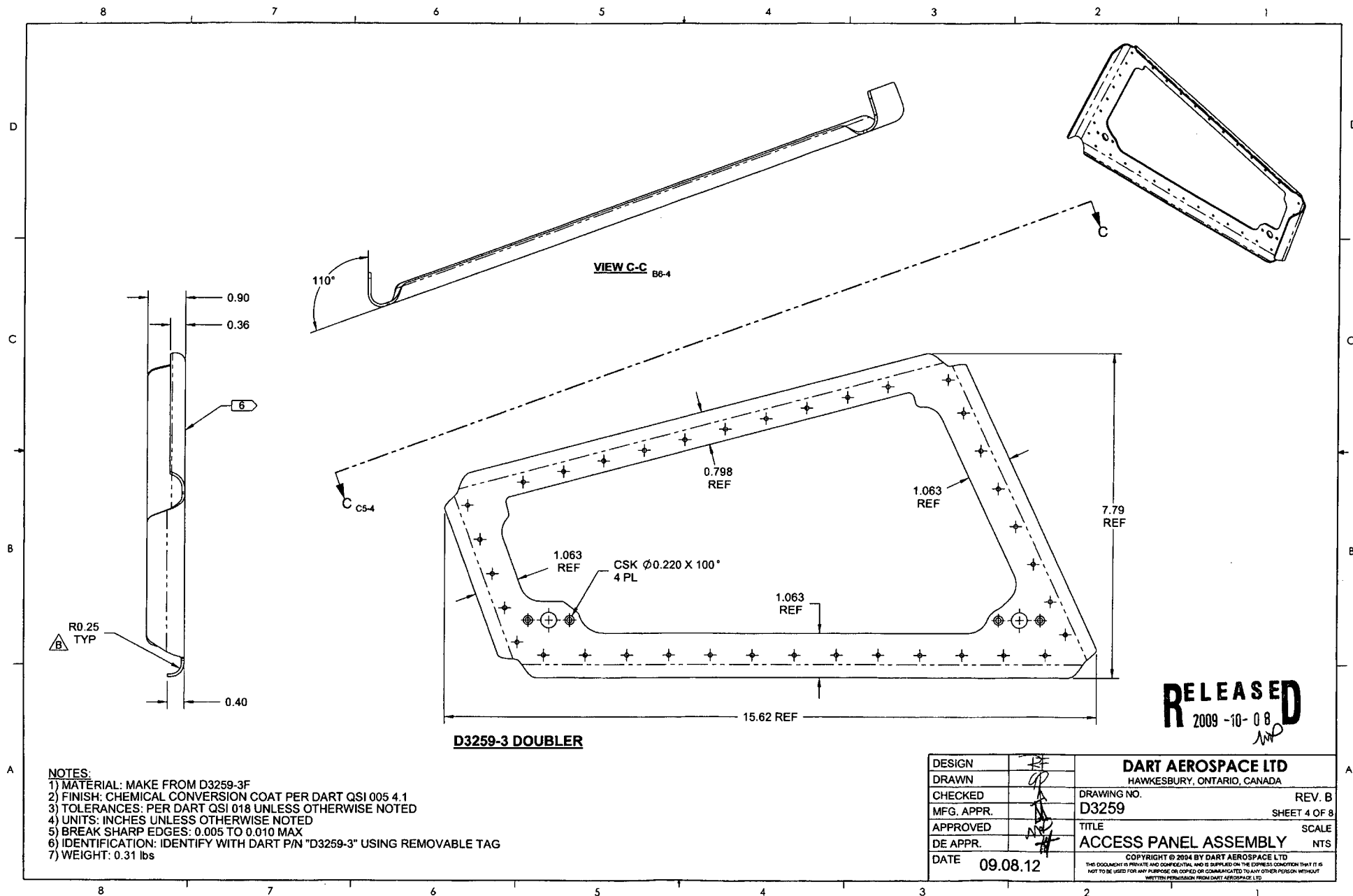
D3259-1 PANEL

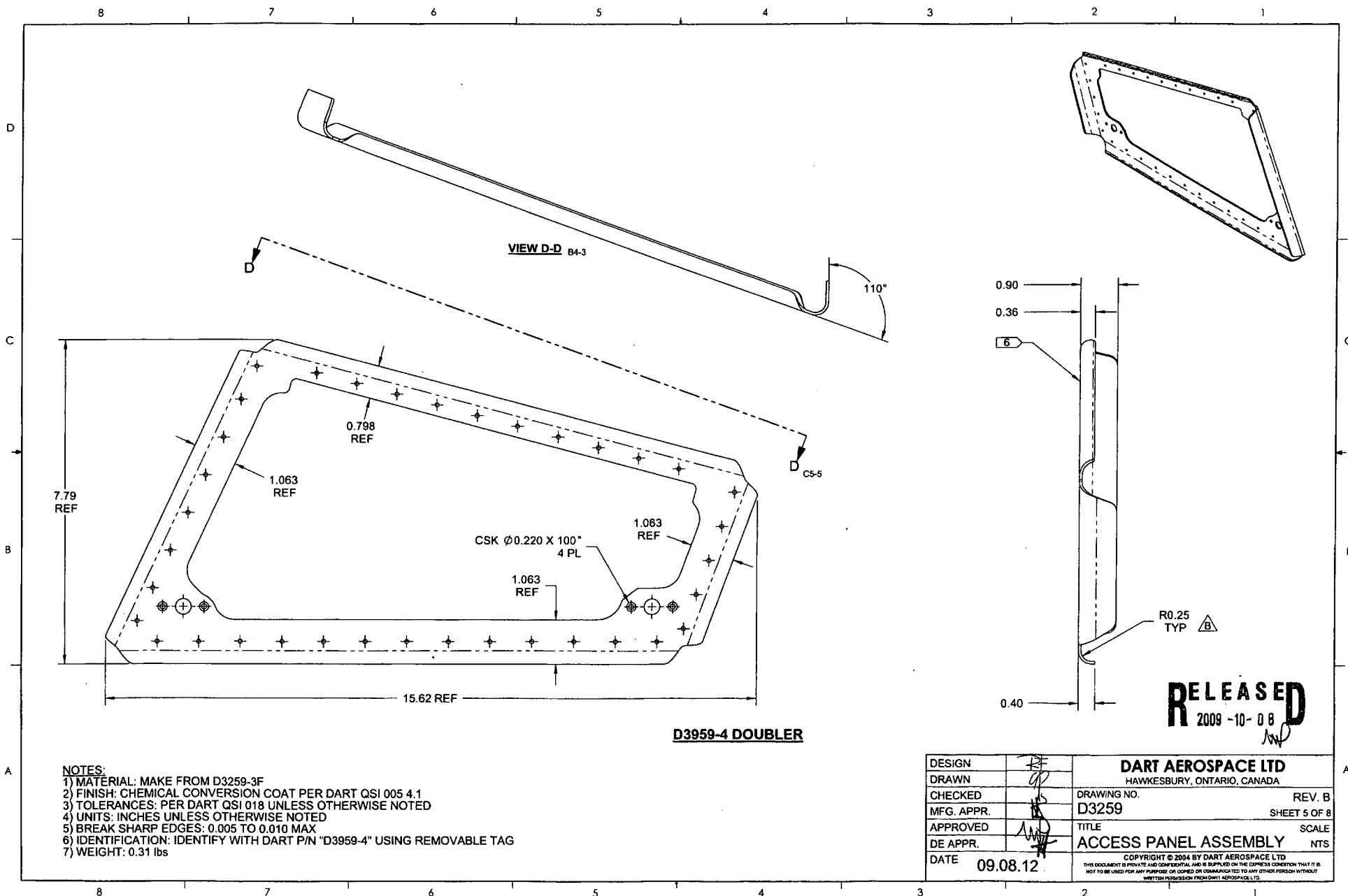
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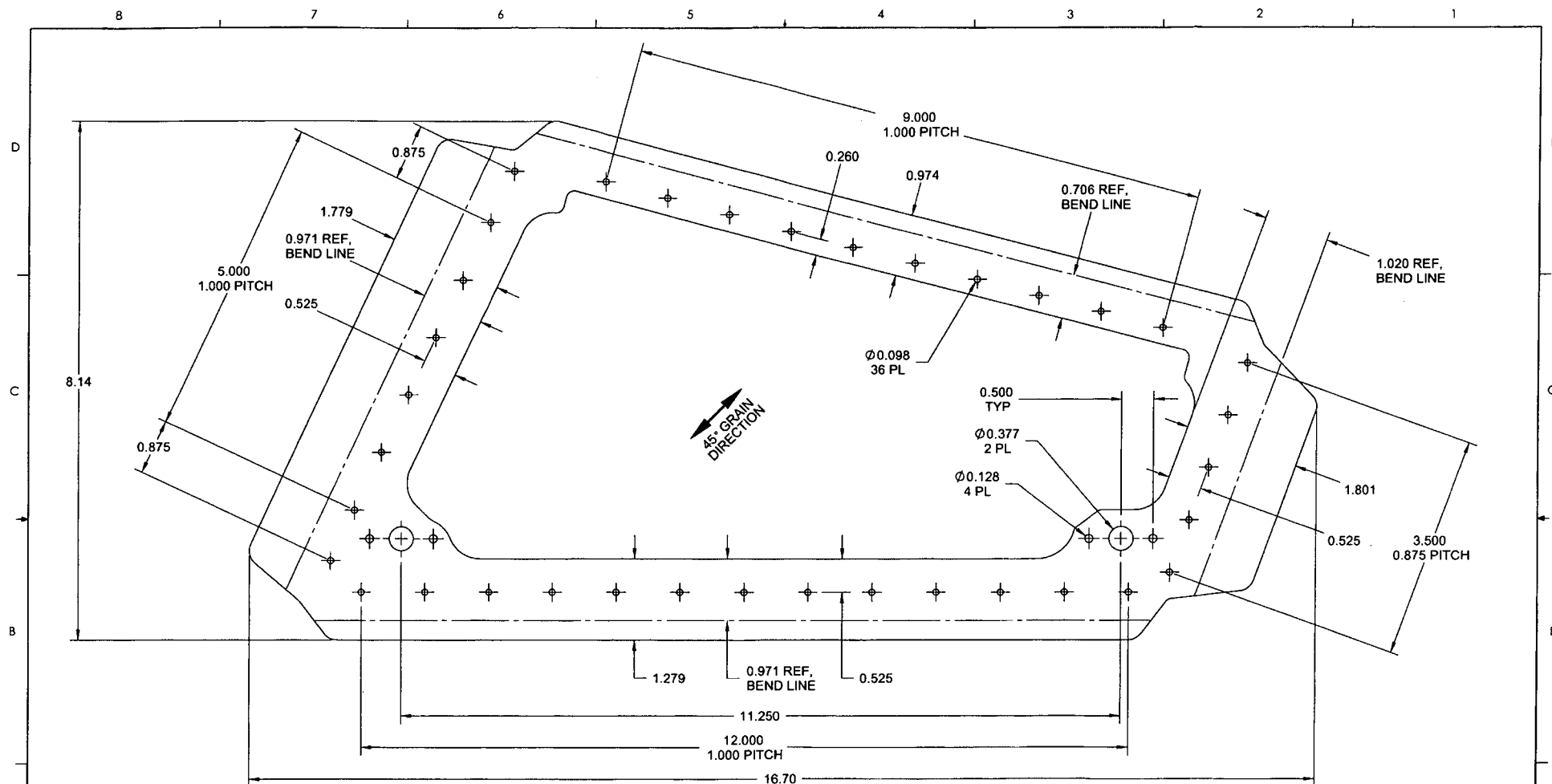
- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.032 THICK PER AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209
REF DART SPEC. M2024T3S.032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3259-1" USING REMOVABLE TAG
- 7) WEIGHT: 0.25 lbs
- 8) MAKE PER DWG FILE "D3259-1B.DXF"

| | | | |
|------------|----------|---|--------------|
| DESIGN | | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. B |
| MFG. APPR. | | D3259 | SHEET 3 OF 8 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | ACCESS PANEL ASSEMBLY | NTS |
| DATE | 09.08.12 | <small>COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small> | |

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2009-10-08





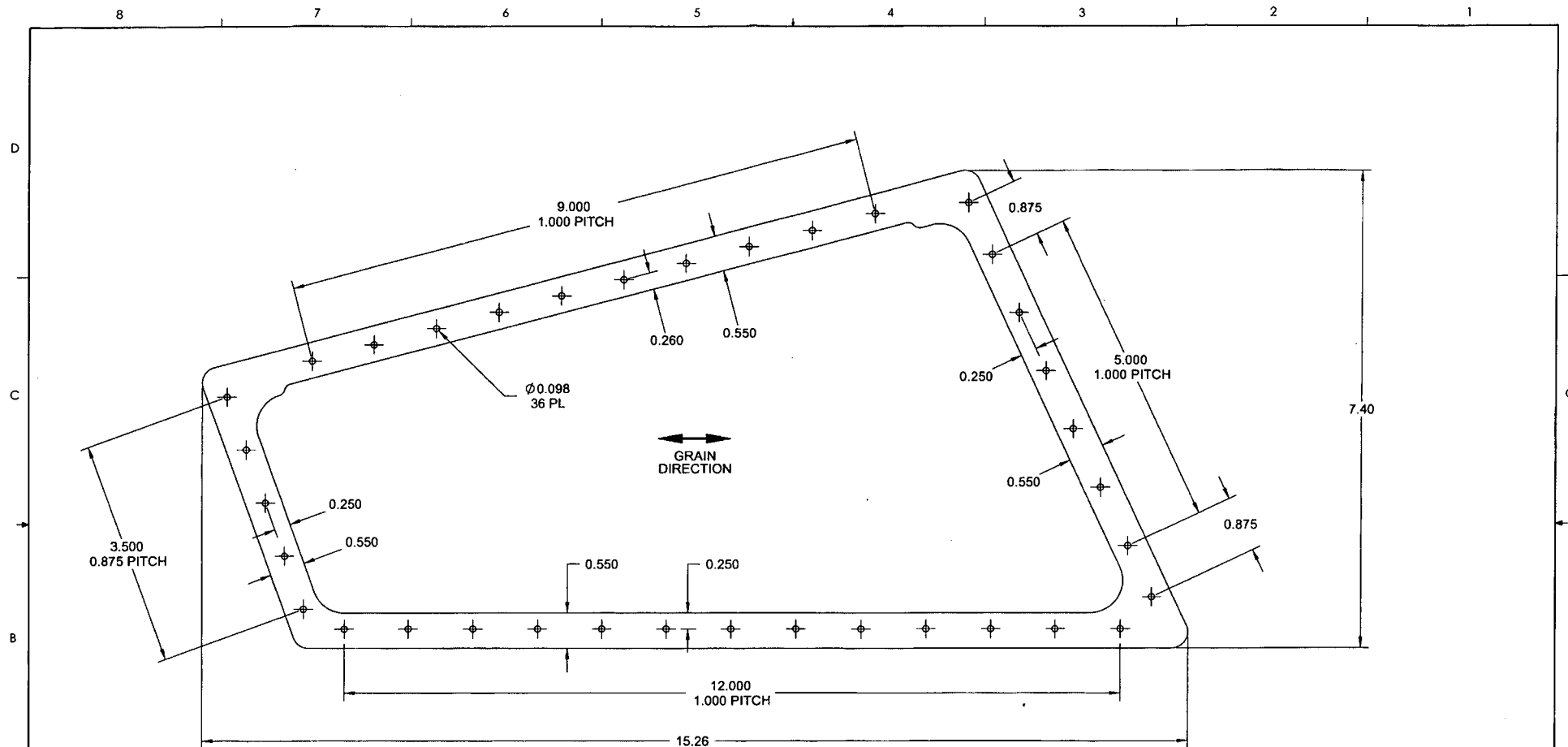


D3259-3F DOUBLER

- NOTES:**
- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.063 THICK PER AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209
REF DART SPEC. M2024T3S.063
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3259-3F" USING REMOVABLE TAG
 - 7) WEIGHT: 0.31 lbs
 - 8) MAKE PER DWG FILE "D3259-3FB.DXF"

| | | | |
|------------|-----------------|---|--------|
| DESIGN | | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. D3259 | REV. B |
| MFG. APPR. | | SHEET 6 OF 8 | |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | ACCESS PANEL ASSEMBLY NTS | |
| DATE | 09.08.12 | <small>COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small> | |

RELEASED
2009-10-08



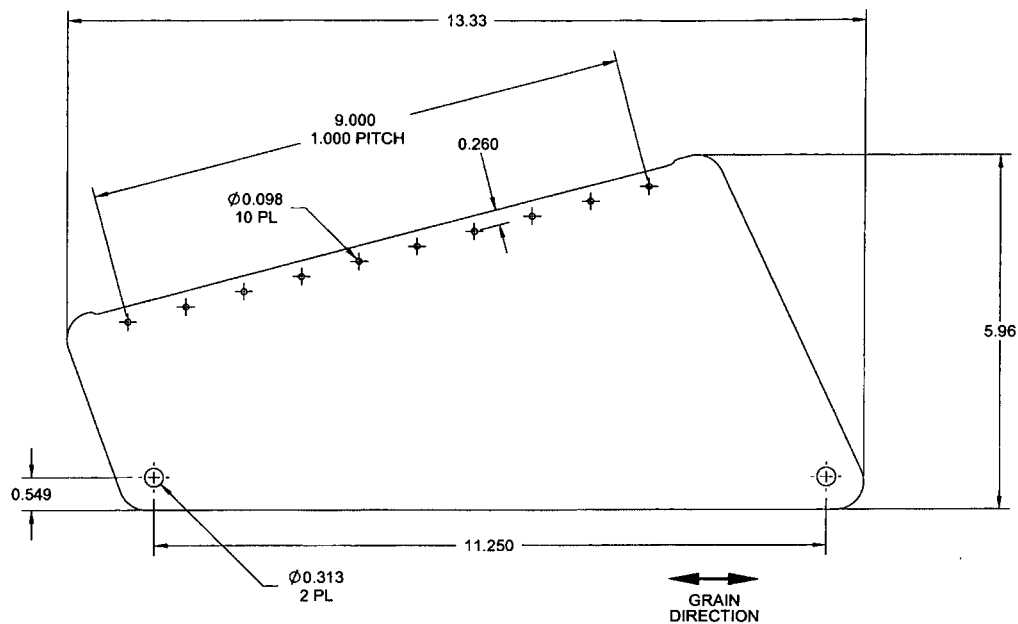
D3259-5 SPACER

RELEASED
2009-10-08

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.032 THICK PER AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209
REF DART SPEC. M2024T3S 032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3259-5" USING REMOVABLE TAG
- 7) WEIGHT: 0.07 lbs
- 8) MAKE PER DWG FILE "D3259-5B.DXF"

| | | | |
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| DESIGN | | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. D3259 | REV. B |
| MFG. APPR. | | TITLE ACCESS PANEL ASSEMBLY | SHEET 7 OF 8 |
| APPROVED | | SCALE | NTS |
| DE APPR. | | COPYRIGHT © 2004 BY DART AEROSPACE LTD | |
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D3259-7 DOOR

RELEASED
2009-10-08

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.063 THICK PER AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209
REF DART SPEC. M2024T3S.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3259-7" USING REMOVABLE TAG
- 7) WEIGHT: 0.35 lbs
- 8) MAKE PER DWG FILE "D3259-7B.DXF"

| | | | |
|--|----------|--|--------------|
| DESIGN | | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. B |
| MFG. APPR. | | D3259 | SHEET 8 OF 8 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | ACCESS PANEL ASSEMBLY | NTS |
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